

Work Order ID 139320

November 23, 2015 11:02:38 AM

139320

Ship Nov 25

For NCR 15-5452

Page 1

Item ID: D3788-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protectors

Start Date: 11/23/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/25/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: SM 20151123

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3788

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D3788
Deburr if necessary

Dwg Rev: A Prog Rev: A 2

SCRAP

(4)

0.15/11/24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(4)

0.15/11/24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

P.T.O.

DQA:

Date: 15/12/09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/11/27

Work Order update only ☐

Work Order: <u>139320</u> Part No. <u>D3788-3</u> NCR No. <u>15-5461</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☒ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐							
Date: 15-11-25		Step #: 100		QTY Effective: 1			MRB (QSI042) Approval DAS 9-89 Nov 25/15				
Description Work Order Deviation				Disposition				Completed By 38 Nov 25 2015			
Found at inspection that D3788-3 was cut has a D3788-4 R.C. DXF file mixed up. and instruction on work order not clear.				D3788-3 can be used for D3788-4. issued work order to re identify D3788-3 has a D3788-4 # 139355 → Ref to NCR15-5452 for corrective action				Lead hand / Supervisor Approval Verification DAS 9-89 15-11-25			
								QC / QA Coordinator Approval DAS 9-89 15-11-25			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☒ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☒ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mis-labeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
OTHER :											

Work Order ID 139320***139320***

Page 2

November 23, 2015 11:02:38 AM

Item ID: D3788-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protectors

Start Date: 11/23/2015 Start Qty: 4.00

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Cust Item ID:

Required Date: 11/25/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									



DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 139320***139320***

Page 3

November 23, 2015 11:02:38 AM

Item ID: D3788-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cabin Floor Protectors

Stop ***NS2***

Start Date: 11/23/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/25/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

pull on
w/o.
#139355

as
D3788-4

ME
15-11-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

November 23, 2015 11:02:47 AM

Page 1

Work Order ID: 139320

139320

Parent Item: D3788-3

D3788-3

Parent Item Name: Cabin Floor Protectors

Start Date: 11/23/2015

Required Date: 11/25/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A 08-08-20 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased			No	100	sf	2,055.000	7.2	33.88235			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

11/15/11/24

Location

Loc Qty

Loc Code

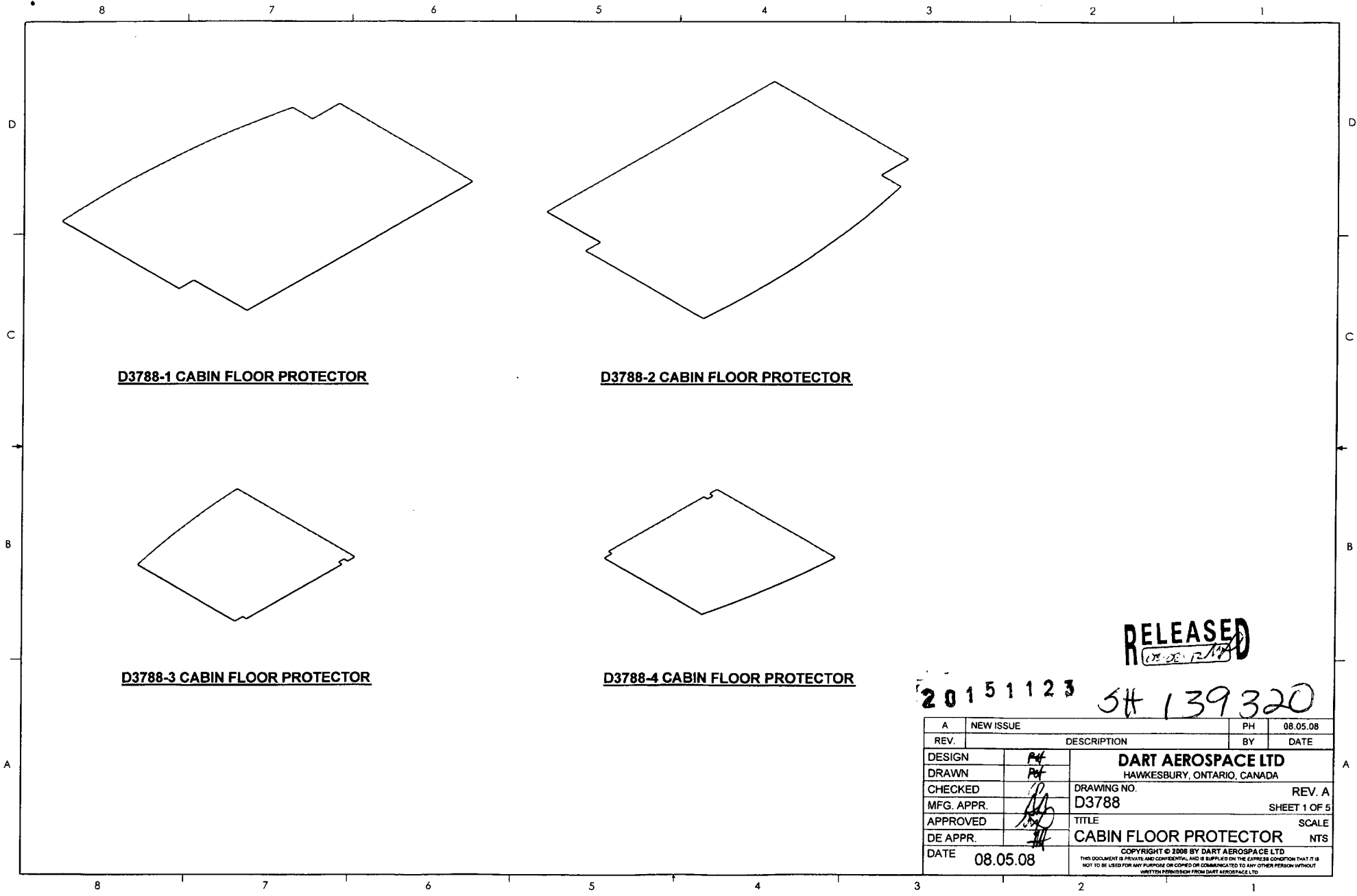
MAT018

2055

2055

m133113

34



D3788-1 CABIN FLOOR PROTECTOR

D3788-2 CABIN FLOOR PROTECTOR

D3788-3 CABIN FLOOR PROTECTOR

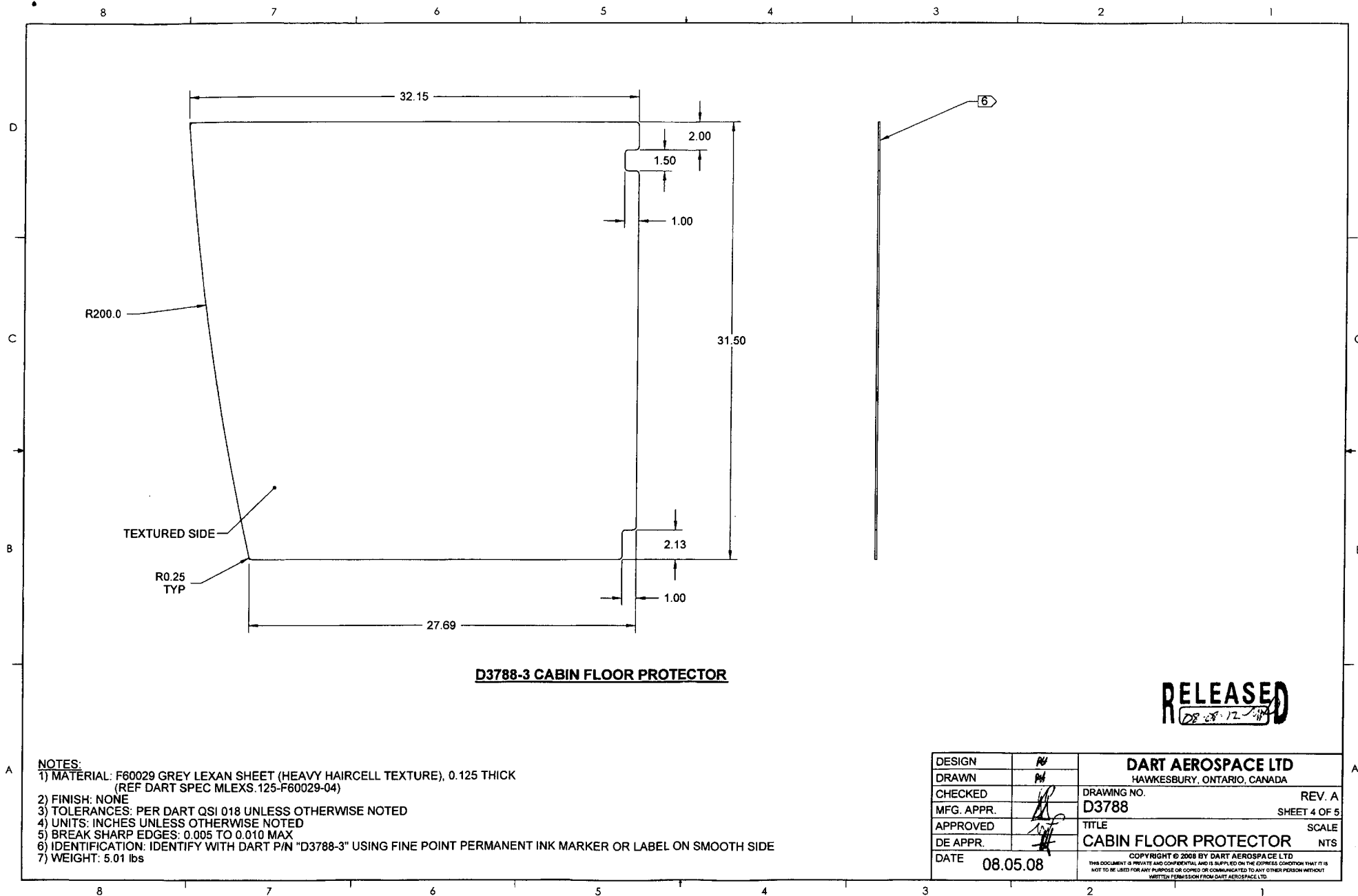
D3788-4 CABIN FLOOR PROTECTOR

RELEASED
(12-28-12)

20151123

54 139320

A		NEW ISSUE		PH	08.05.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	PH			SHEET 1 OF 5	
CHECKED	PH			DRAWING NO. D3788	
MFG. APPR.	PH			TITLE	
APPROVED	PH			SCALE	
DE APPR.	PH	CABIN FLOOR PROTECTOR		NTS	
DATE		08.05.08		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3788-3 CABIN FLOOR PROTECTOR

RELEASED
08-28-12

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
(REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3788-3" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE
- 7) WEIGHT: 5.01 lbs

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO. D3788	REV. A
MFG. APPR.	PH	SHEET 4 OF 5	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CABIN FLOOR PROTECTOR	NTS
DATE	08.05.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

